

Date: Friday, 16/01/2009 7:41:05 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GAS SPRING		
Job Number	: 44858					
Estimate Number	: 13065					
P.O. Number	:			Part Number	: D2807041	
This Issue	: 16/01/2009	S.O. No. :		Drawing Number	: D2807 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: PURCHASED PARTS		
Previous Run	: 43901			Drawing Revision	: E	
Written By				Material	:	
Checked & Approved By	<u>C20910416</u>			Due Date	: 28/01/2009	
Comment	: Est: D 07.11.12 ecn1019, replaces D2807 DD Est Rev:E 08-02-12 ECN 1111 DD verified by: ec			Qty:	40	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: <u>TP90</u>	Order as per Dwg D2807 Possible supplier:Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N Material release note is required
2.0	615 16450 115N	Gas Spring
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) SUPPORT PROP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
5.0	D36711	Placard
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) PLACARD batch: <u>B43945</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/01/2009 7:41:05 AM
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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-install D3671-1 as per dwg D2807

Ep09/02/19 *41X*

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/19 *41*

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *41*

9/2/19

SB

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23 *41*

Job Completion



MF
09-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

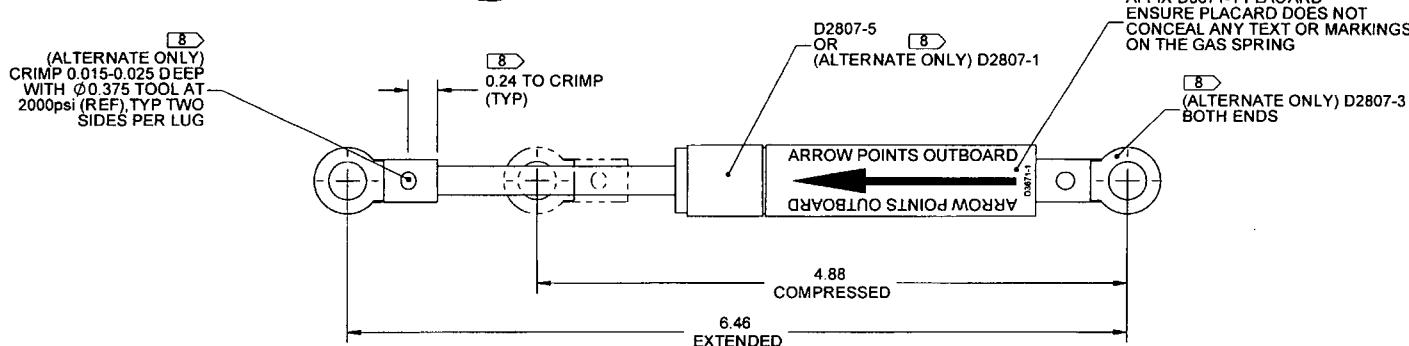
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

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 WITHOUT NOTICE
 WORK ORDER
 NO. 44858



D2807-041 GAS SPRING

RELEASED

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS)

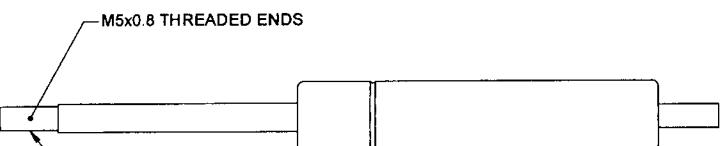
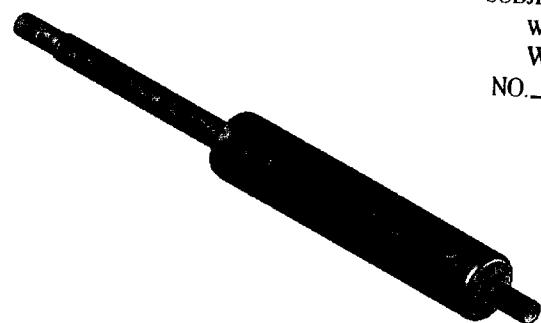
△

E	ADD D2807-5 GAS SPRING; D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	IPH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -341 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD	
DRAWN	4	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. E
MFG. APPR.	4	D2807	SHEET 1 OF 3
APPROVED	4	TITLE	SCALE
DE APPR.	4	GAS SPRING	NTS
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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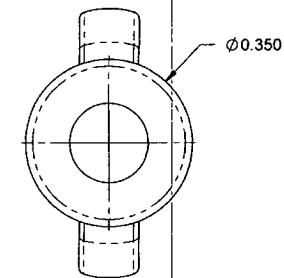
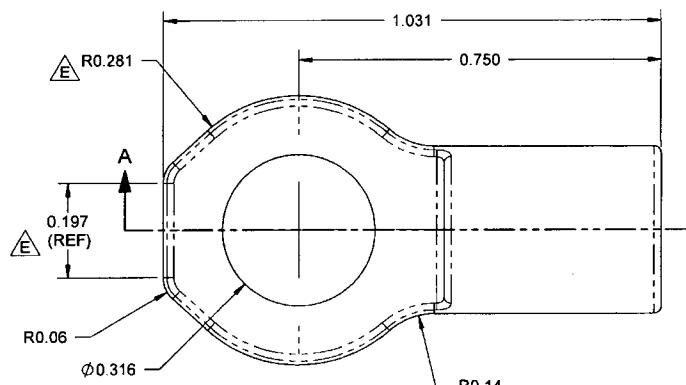
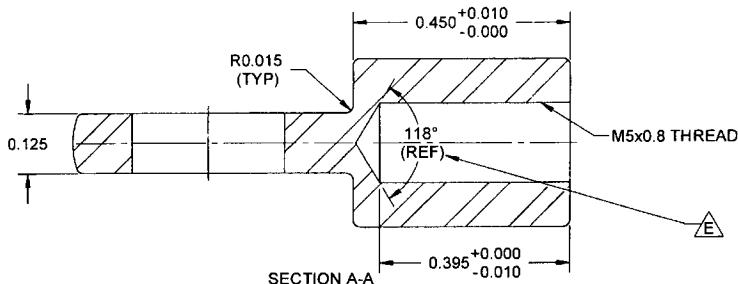
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WORK ORDER
NO. 44858

8 7 6 5 4 3 2 1



M5x0.8 THREADED ENDS
ACCEPTABLE TO TRIM ENDS UP
TO 0.050 TO MEET D2807-041
COMPRESSED DIMENSION
(TYP)

D2807-1 GAS SPRING
SCALE 1:1



D2807-3 LUG

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF656050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

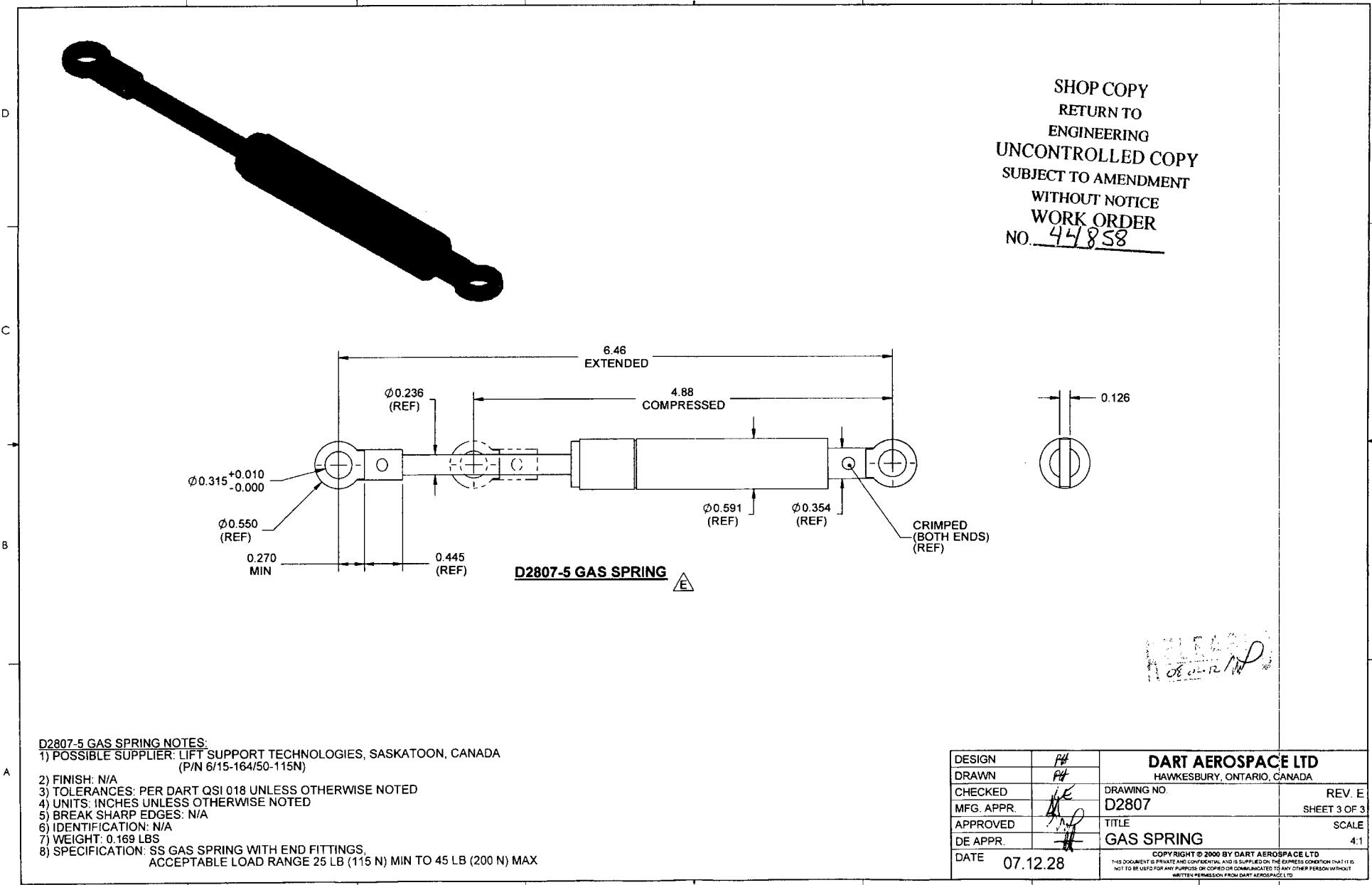
D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	<i>14</i>	DART AEROSPACE LTD			
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CHECKED	<i>FE</i>	DRAWING NO.			
MFG. APPR.	<i>14</i>	D2807			
APPROVED	<i>14</i>	REV. E			
DE APPR.	<i>14</i>	SHEET 2 OF 3			
DATE	07.12.28				
TITLE	GAS SPRING				
SCALE	4.1				

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8 7 6 5 4 3 2 1



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MFG. APPR.	<i>M</i>	D2807	REV. E
APPROVED	<i>AM</i>	SHEET 3 OF 3	
DE APPR.	<i>AM</i>	TITLE	SCALE
DATE	07.12.28	GAS SPRING	4:1

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LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK
S7N 1Y9

Packing Slip

Date	Packing Slip #
2/12/2009	4763

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

P.O. No.	Rep	Ship Date	Ship Via
7990	Nolan	2/12/2009	Purolator

Qty	Description
40	D2807 - 615-056-168-115N Stainless Gas Spring Shipping via PUROLATOR collect on account 7684382 - Tracking # 329070341295 Total GST Business Number: 875007718

Please remit to above address. Thank you for the business.



303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: lstech@lstech.ca www.liftsupporttechnologies.com

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

40 Units: D2807 - 615 16450 115N Gas Spring

Manufactured from 304 Stainless Steel

Country of Manufacture: Canada

Date of Manufacture : 2008

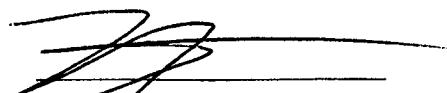
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 00007990

Invoice # 4763

L S Technologies Inc Canada



Nolan Fehr
Manager

A handwritten signature in black ink, appearing to read "Nolan Fehr", is written over a horizontal line. Below the signature, the name "Nolan Fehr" is printed in a standard font, followed by the title "Manager" in a smaller font.